

Work Order ID 94315

December-07-12 8:01:39 AM

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Item ID: D2739

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 07/12/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 14/12/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12-12-07 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								
100		0.00							
100	Skidtubes								
Skidtubes		0.00							
Skidtubes	Memo								
	1-Cut D2600-5 to length as per Dwg D2739.								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Bevel Fwd end of extrusion and Deburr holes and ends.								
	5-Deburr								
120		0.00							
120	Chemical Conversion Coat per QSI005 4.1								
HandFinish		0.00							
Hand Finishing	Memo								

(4) SAO 12-12-10

(4) SAO 12-12-10

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Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 07/12/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 14/12/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DA 8:05
(4) DP 12-12-10

140

Identify as per dwg & Stock Location: LG

0.00

140

Packaging

Memo

0.00

Packaging

(4) SAD 12-12-10

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/12/10

ME 12-12-10

Picklist Print

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Work Order ID: 94315

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Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 07/12/2012

Required Date: 14/12/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-080		Manufactured	No				Each	144.0000		4			
D2600-5-080									**				
Extrusion 'I Beam' thin													

SAD 12-12-10

Location

Loc Qty

Loc Code

LG

144

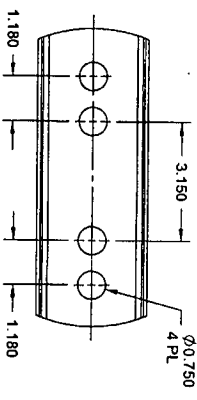
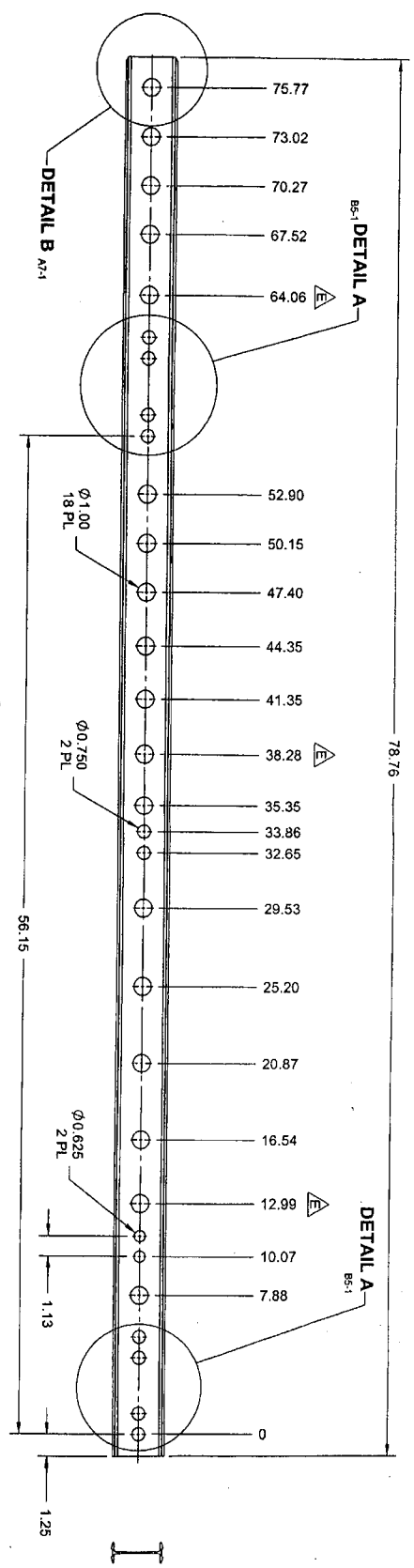
73867

1

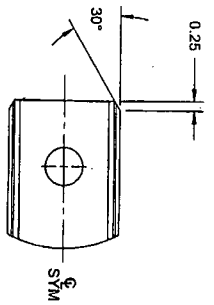
90683

143

4



DETAIL B
C7-1
SCALE 3X



DETAIL A
D7-1, D2-1
SCALE 3X

- NOTES:
- 1) MATERIAL: MAKE FROM D2800-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES
 - 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N: D2739 AND B/N PER DART OSI 044 6.1
 - 7) WEIGHT: 3.41 LBS

E	ADD/REMOVE HOLES FOR DART A7-1, 38.28 WAS 38.35 (D2-1) 64.06 WAS 64.17 (D2-1) 75.77 WAS 75.82 (D2-1)	CP	10.10.08
D	ADD BEVEL TO PWD END, ADD DETAIL B	CB	07.05.29
C	ADD/REMOVE HOLES FOR COMPATIBILITY WITH AIRCRAFTER	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAFTER	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
DESIGN	DS	DESCRIPTION	DART AEROSPACE USA, INC.
DRAWN	DS	DRAWING NO.	PORT HADLOCK VA
CHECKED	DS	TITLE	D2739
MFG. APPR.	DS	REV. E	SHEET 1 OF 1
DE APPR.	DS	SCALE	1:1
DATE	10.10.08	WEB	NTS

RELEASED
2010-11-01

UNCONTROLLED
SUBJECT TO
WARRANTY

NO. 94315 M25
12-12-07

